



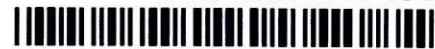
Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

6

D4037-3

Job Sheet 174513



Part No: D4037-3

Job Qty: 2 ea

Part Name: Fwd Crossbeam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP REV:B AS PER REV B 10-04-19
JLM VERIFIED BY:EC IPP REV:D AS PER ECN 11-554 11-05-24 JLM VERIFIED BY:DD IPP REV C:AS PER
ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/9/18	4/9/18	0.00	0.00	Start Up Waterjet		DC B/03/27
100	Waterjet	2 pcs	4/9/18	4/9/18	0.00	2.11	Waterjet1		DC K/03/27
110	CNC Vertical Machining	2 pcs	4/9/18	4/9/18	2.85	5.71	HAAS1-4		K+ 18/04/27
120	QC	2 pcs	4/9/18	4/9/18	0.00	0.00	QC2 Machining-2		K+ 18.04.27
130	QC	2 pcs	4/9/18	4/9/18	0.00	0.00	QC8 Machining-2		18/04/30
140	HandFinish	2 pcs	4/9/18	4/9/18	0.00	0.42	HandFinish1		SA 18-04-30
150	Powdercoat	2 pcs	4/9/18	4/9/18	0.00	0.43	Powdercoat1		BL 18-04-30
160	QC	2 pcs	4/9/18	4/9/18	0.00	0.00	QC3		APR 3 U 2018
170	Packaging	2 pcs	4/9/18	4/9/18	0.00	0.00	Packaging3-2		DC 18-05-02
180	QC21-SA	2 Ea	4/9/18	4/9/18	0.00	0.00	QC21		21 MAY 17 2018

Part Op 100 - Cut blank as per file D4037-3_BLANK

Descriptions: 110 - MACHINE AS PER FOLI FA878 AND DWG

M 139760 START: 1:05. OUT: 3:00 FINISH: 1:35.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X16.000	6061-T6 Bar 1.00 X 16.00	7.8000 ft (3.9 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X16.000	8	24	0

Part Specifications

Specifications could not be found.

Plex 3/16/18 2:19 PM Dart.Gagnon.Michelle



Container No: S055686



Part: D4037-3

Job No: 174513

Serial No/Batch: S055686

Revision:

Inspector:

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 03/27/18

DART AEROSPACE LTD		Work Order:	174513
Description: Fwd Crossbeam		Part Number:	D4037-3
Inspection Dwg: D4037 Rev: E		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	+/-0.030	41.66	✓		+	TYPE
0.92	+/-0.030	0.920	✓		Kt-05	vern.
1.75	+/-0.030	1.750	✓		" "	" "
0.92	+/-0.030	0.920	✓		" "	" "
2.125	+/-0.010	2.125	✓		" "	" "
Ø0.316	+0.006/-0.001	0.316	✓		" "	" "
Ø0.391	+0.006/-0.001	0.391	✓		" "	" "
0.28	+/-0.030	0.280	✓		" "	" "
R0.19	+/-0.030	0.190	✓		—	R-G
0.63	+/-0.030	0.625	✓		Kt-05	vern.
1.50	+/-0.030	1.500	✓		✓	" "
1.20	+/-0.030	1.176	✓		" "	" "
1.95	+/-0.030	1.940	✓		" "	" "
6.00	+/-0.030	6.000	✓		" "	" "
10.54	+/-0.030	10.54	✓		" "	" "
1.38	+/-0.030	1.377	✓		" "	" "
1.75	+/-0.030	1.750	✓		" "	" "
7.79	+/-0.030	7.79	✓		Block	H-G
5.80	+/-0.030	5.80	✓		Kt-05	vern.
2.250	+/-0.010	2.250	✓		" "	" "
0.875	+/-0.010	0.875	✓		" "	" "
6.000	+/-0.010	6.000	✓		" "	" "
7.75	+/-0.030	7.750	✓		" "	" "
1.125	+/-0.010	1.125	✓		" "	" "
9.29	+/-0.030	9.290	✓		" "	" "
5.17	+/-0.030	5.17	✓		" "	" "
10.79	+/-0.030	10.79	✓		" "	" "
0.91	+/-0.030	0.910	✓		" "	" "
0.09 x 45°	+/-0.030 x +/-0.5°	0.090 x 48	✓		" "	" "
0.31	+/-0.030	0.315	✓		" "	" "
0.25	+/-0.030	0.253	✓		" "	" "
0.530	+/-0.010	0.522	✓		" "	" "
0.25	+/-0.030	0.260	✓		" "	" "
0.550	+/-0.010	0.550	✓		" "	" "
3.00	+/-0.030	3.000	✓		" "	" "
2.00	+/-0.030	2.000	✓		" "	" "
1.00	+/-0.030	1.000	✓		" "	" "

DART AEROSPACE LTD		Work Order:	
Description: Fwd Crossbeam		Part Number:	D4037-3
Inspection Dwg: D4037 Rev: E		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.32	+/-0.030	0.032	✓		Hand	R-G
0.200	+/-0.010	0.201	✓		HT-05	vern.
0.64	+/-0.030	0.650	✓		Kt-05	vern.
0.45	+/-0.030	0.450	✓			
0.70	+/-0.030	0.700	✓			
0.25	+/-0.030	0.250	✓			
R0.13	+/-0.030	0.130	✓			
0.49	+/-0.030	0.490	✓			
0.06	+/-0.030	0.06	✓			

DAS

Measured by: Kt 9-89	Audited by: [Signature]	Preliminary Approval:
Date: 2018-04-27	Date: 18/04/26	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	10.10.07	Dimensions updated per Dwg Rev C	KJ	
C	11.06.21	Dwg Rev updated	KJ	
D	17.02.16	Dimensions updated per Dwg Rev E	KJ	

504 7751

M606/T6B 1.000 x 18.000